



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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RBST4241
Job Sheet 199116



Part No: RBST4241

Job Qty: 2 pcs

Part Name: Tri Roller Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17905 -18435

Note: DWG RBST4241 Rev1 IPP Rev. A 19.08.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	10/7/19		0.00	2.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	2 pcs	10/7/19		0.00	0.00	QC 5 - 10		DAS 40 OCT 25 2019 9-88
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	2 pcs	10/7/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S226487



Part: RBST4241

Job No: 199116

Serial No/Batch: S226487

Revision: 1

Inspector:

Exp Date:

Instructions:

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CANADA
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Date: 10/26/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	2 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

OK 25/10/19

86-6
12
510
DAS
21
9-59

OCT 25 2019

Part Op 110 - Small Fab-3 (Small Fab) -Assemble as per DWG. Sheet 1
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97705A406	Screw 8-32 X 1/4 S.S. (Mcmaster)	2 Ea (1 ea)	110-Small Fab - 1	5206553
RBST4241-1	Roller Fixture	2 pcs (1 ea)	110-Small Fab - 1	5214256
RBST4241-11	Primary Seat	2 (1 ea)	110-Small Fab - 1	5215382
RBST4241-13	Secondary Seat	2 (1 ea)	110-Small Fab - 1	5215511
RBST4241-15	Locating Pin	4 (2 ea)	110-Small Fab - 1	5214984
RBST4241-3	Retainer	2 (1 ea)	110-Small Fab - 1	5214494
RBST4241-5	Roller	6 pcs (3 ea)	110-Small Fab - 1	5212512
RBST4241-7	Guide	2 (1 ea)	110-Small Fab - 1	5215779
RBST4241-9	Pin	2 (1 ea)	110-Small Fab - 1	5217127

12624

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97705A406	2	0	0
	RBST4241-1	2	0	0
	RBST4241-11	2	0	0
	RBST4241-13	2	0	0
	RBST4241-15	4	0	0
	RBST4241-3	2	0	0
	RBST4241-5	6	3	0
	RBST4241-7	2	0	0
	RBST4241-9	2	0	0
Part Specifications				
Specifications could not be found.				

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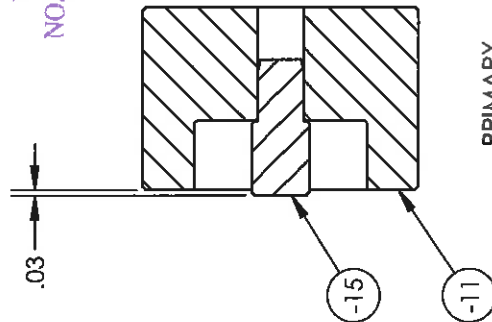
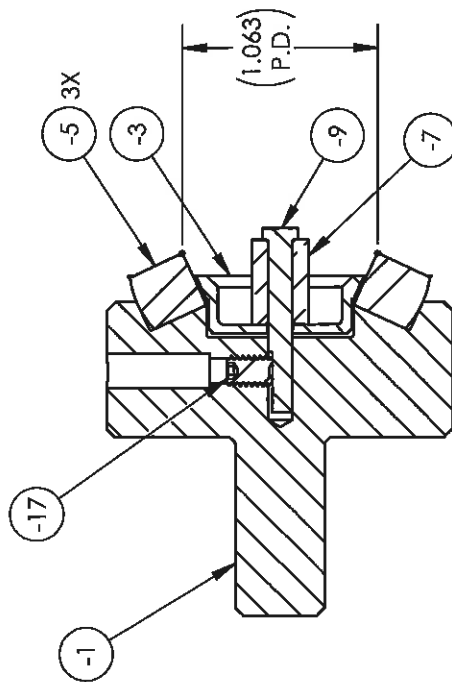
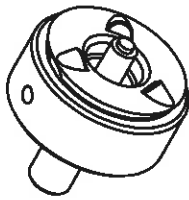
REV		ECR	REVISIONS		DESCRIPTION	DATE	INITIAL	APPROVED
1					RELEASED FOR PRODUCTION.	4/6/2017	DPD	JAG

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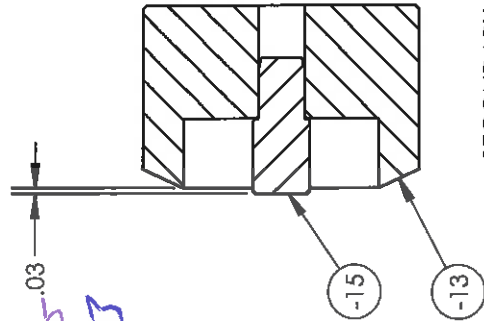
WORK ORDER

NO. 19916 MLS

1908-13



PRIMARY
SEAT



SECONDARY
SEAT

NOTE:
USED FOR BEARING 412-010-182-103.



TITLE		DRILL PRESS SWAGING TOOL		REV		1	
DWG NO.		RBST4241					
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/16 XX ± .01 AUGUST 2015 X ± .1 SURFACES ± 125					
HEAT TREAT		1. BREAK ALL SHARP EDGES 2. INTERPRET DIM AND TOL PER 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009					
SPEC		DRAWN BY: DD 04/05/2017 CHECKED: SM 04/05/2017 QA APPR: JL 04/05/2017 APPROVED: JAG 04/06/2017					
BIO		SCALE 1:1		DATE 4/5/2017		SHEET 1 OF 9	
ASSY QTY		Part #		UNIT QTY		Description	
		-1	1	1	1	ROLLER FIXTURE	0-1 DRILL ROD
		-3	1	1	1	RETAINER	BRONZE
		-5	3	3	3	ROLLER	STEEL
		-7	1	1	1	GUIDE	BRONZE
		-9	1	1	1	PIN	STEEL
		-11	1	1	1	PRIMARY SEAT	4140/4142
		-13	1	1	1	SECONDARY SEAT	4140/4142
		-15	2	2	2	LOCATING PIN	1018/1020 CR
		-17	1	1	1	SOCKET HEAD SET SCREW	S.S.
		BIO	-17	1	1	(MCMASTER-CARR #9705A406)	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)											
Description Work Order Deviation				Disposition											
				Completed By											
				Lead hand / Supervisor											
				QC / QA Coordinator											
Root Cause				FAULT CATEGORY											
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐					
				Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐					
				Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐					
				Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐					
				Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐					
				Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐					
				Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐							
				Other/Details: _____											